

Work Order ID 74480

Monday, October 03, 2011 10:25:16 AM



Page 1

Item ID: D2662-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH In 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/10/03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2662	Rev D								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.
Inspect part number and batch number are programmed

MACHINE AS PER FOLIO FB068 & DWG

DWG REV: D

FOLIO REV: AA

JL 11-11-07

(10)

φ

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

JL 11-11-07

10

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74480

Monday, October 03, 2011 10:25:16 AM



Page 2

Item ID: D2662-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH In 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

JA 11-11-07

10

0

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

BA 11/11/07

10

0

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

10 052 11-11-07

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[REDACTED]

Monday, October 03, 2011 10:25:16 AM



[REDACTED]

1

[illegible][illegible][illegible]

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19-20-1986
21-2

**Insp.
Stamp**

[illegible]

Powder Coating

8-40 0.00
RATURE: 32.0 F
9-10

[illegible]

Quality Control

[illegible]

Packaging

PPH
DENU

10X Ø m-k 11/14/08

10 BR 11-11-8.

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74480

Page 4

Monday, October 03, 2011 10:25:16 AM

Item ID: D2662-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH In 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/11/8	

MF
11-11-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 10:25:54 AM

Page 1

Work Order ID: 74480



Parent Item: D2662-1



Parent Item Name: Saddle, LH In 206

Start Date: 9/30/2011

Required Date: 10/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.06.22 Removed P/O for powder coat EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001

Manufactured No

100

Each

4.0000

1

10



11-11-07

Saddle Billet

Location

Loc Qty

Loc Code

MAT040

4

66965

1

69677

2

73768

1

74648

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 74480
Description: 206 Saddle, Inboard, Left side	Part Number: D2662-1
Inspection Dwg: D2662 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.121	.121	.121	.120	.120	
B	0.100	0.140		.132	.133	.133	.133	.133	
C	1.125	1.145		1.140	1.140	1.139	1.139	1.139	
D	0.615	0.685		.685	.685	.685	.685	.685	
E	0.240	0.260		.247	.247	.248	.248	.248	
F	1.313	1.343		1.325	1.324	1.325	1.325	1.325	
G	0.210	0.230		.221	.221	.220	.220	.220	
H	0.100	0.180		.140	.140	.140	.140	.140	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.580	1.580	1.579	1.579	1.579	
K	0.235	0.240		.238	.238	.238	.238	.238	
L	0.100	0.120		.113	.113	.113	.113	.113	
M	0.990	1.010		1.000	1.000	1.000	1.000	1.000	
N	0.510	0.515		.512	.512	.512	.512	.512	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		.313	.313	.313	.313	.313	
S	0.315	0.322		.316	.316	.316	.316	.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		.798	.800	.797	.797	.797	
W	0.540	0.560		.550	.550	.551	.550	.551	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		.257	.257	.257	.257	.257	
Z	0.912	0.932		.919	.918	.922	.922	.922	
AA	0.490	0.510		.501	.501	.497	.501	.498	
AB	0.178	0.198		.188	.188	.188	.188	.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<u>JA</u>
Date:	11-11-07

Audited by:	<u>HA</u>
Date:	11/11/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 74480
Description: 206 Saddle, Inboard, Left side		Part Number: D2662-1
Inspection Dwg: D2662 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.121	.120	.120	.120	.120	
B	0.100	0.140		.132	.133	.132	.133	.133	
C	1.125	1.145		1.140	1.139	1.140	1.139	1.139	
D	0.615	0.685		.685	.685	.685	.685	.685	
E	0.240	0.260		.247	.247	.247	.247	.248	
F	1.313	1.343		1.324	1.324	1.324	1.324	1.324	
G	0.210	0.230		.220	.220	.220	.220	.220	
H	0.100	0.180		.140	.140	.140	.140	.140	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.580	1.579	1.580	1.579	1.579	
K	0.235	0.240		.238	.238	.238	.238	.238	
L	0.100	0.120		.113	.113	.113	.113	.113	
M	0.990	1.010		1.000	1.000	1.000	1.000	1.000	
N	0.510	0.515		.512	.512	.512	.512	.512	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		.313	.313	.313	.313	.313	
S	0.315	0.322		.316	.316	.316	.316	.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		.795	.796	.797	.797	.797	
W	0.540	0.560		.551	.551	.551	.551	.551	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		.257	.257	.257	.257	.257	
Z	0.912	0.932		.922	.922	.921	.922	.922	
AA	0.490	0.510		.496	.496	.500	.498	.497	
AB	0.178	0.198		.188	.188	.188	.188	.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>Y</u>
Date: <u>11-11-07</u>

Audited by: <u>MA</u>
Date: <u>11/11/07</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

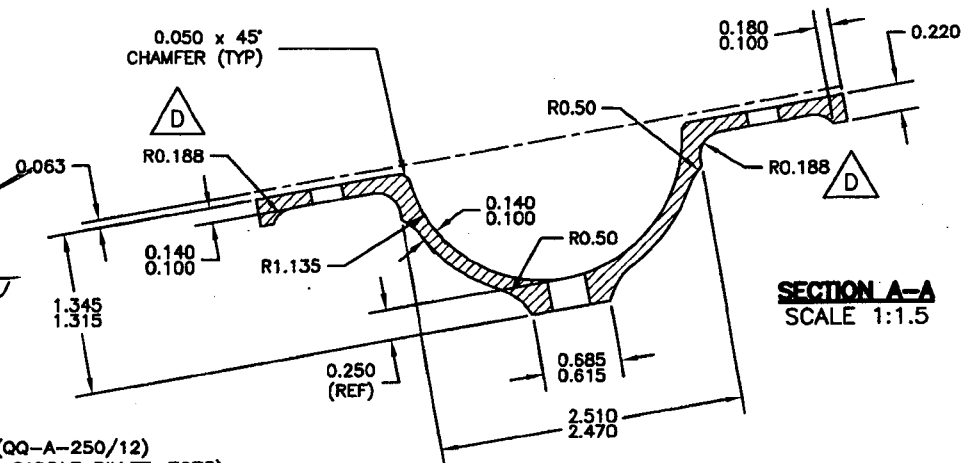
DART

DESIGN A	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2662	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE INSIDE		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORP' DEO 9122/9102/9095/9137	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

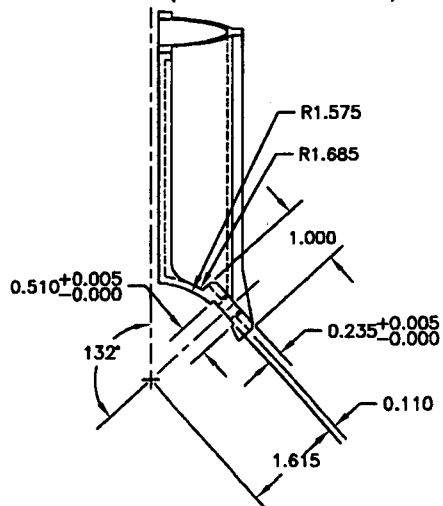
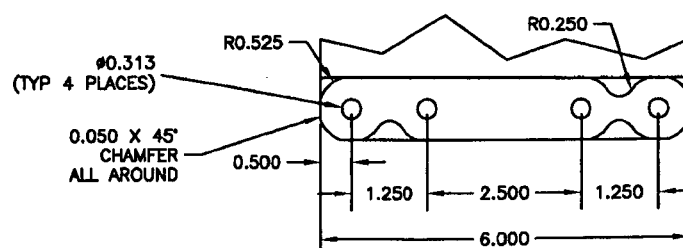
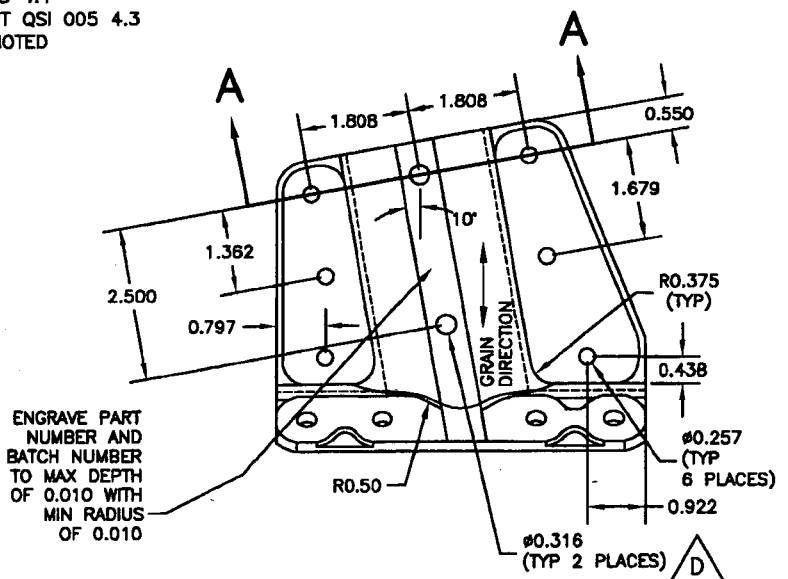
RELEASED

07.02.02

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **74480 M.L.J**
11/10/03

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2662-2 IS OPPOSITE)

**D2662-1 SADDLE INSIDE****Copyright © 1997 by DART AEROSPACE USA, INC.**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries